

Work Order ID 63624

Friday, November 05, 2010 10:24:15 AM

Page 1

Item ID: D3916-041

Accept

Setup Start

Revision ID:

Item Name: Rib Assembly

Stop

Start Date: 11/5/2010 Start Qty: 6.00

Required Date: 11/12/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3916

A

100

0.00

Large Fab

Large Fab

Memo

0.00

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9567

*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***

3- Trim access tube material to finish size as per dwg D3916

4- Drill and chamfer holes as per dwg D3916-1 using DT9605

5- weld bushing as per dwg D3916

6- grind welds flush

⑥ LM 10/11/24

590 10-11-17
Cpl 10-11-24

110

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Solubr

⑥ XG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC10- Inspect visual per QS1004- ground welds

0.00

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

26

10/11/25

SP

10/11/25

BS 10-11-25

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 63624

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Start Date: 11/5/2010

Required Date: 11/12/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1 Manufactured No



Bushing

100

Each

40.0000

7



42
CPL 10-11-24

Location

Loc Qty

Loc Code

ST084

21

56942

21

WA

19

- 54072

9

- 61379

10

B63875 → (11) (14)
21 18

10

M304TS0.750W.049

Purchased

No

100

f

298.6790

4.166

26.31158



304 SQ Tube .75x.75x.049W



SAD 10-11-17

Location

Loc Qty

Loc Code

MAT

33.97876794

113763

0

114323

20.0582189

114677

7.69741

114835

6.223139

MAT017

3.68448E-05

114298

3.6845E-05

WA

264.7002

114992

33.7547

115260

230.9455

26.3116

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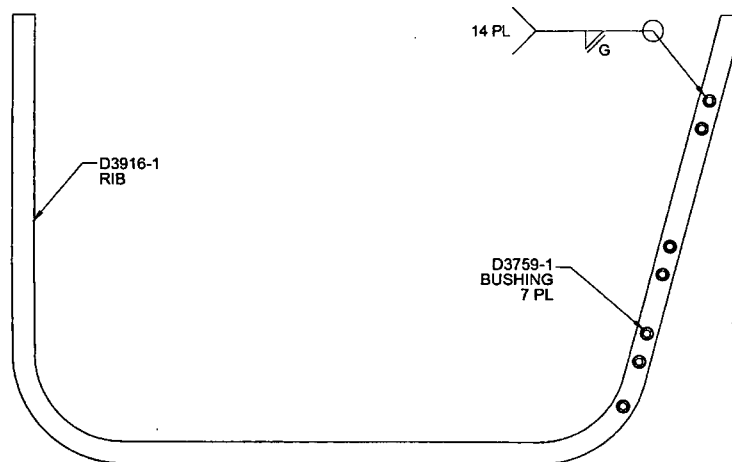
8 7 6 5 4 3 2 1

D

C

B

A



D3916-041 RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63624

210-11-05

RELEASED
2010-03-12
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>B</i>	D3916	SHEET 2 OF 4
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	RIB ASSY, 350 BASKET NTS	
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8 7 6 5 4 3 2 1

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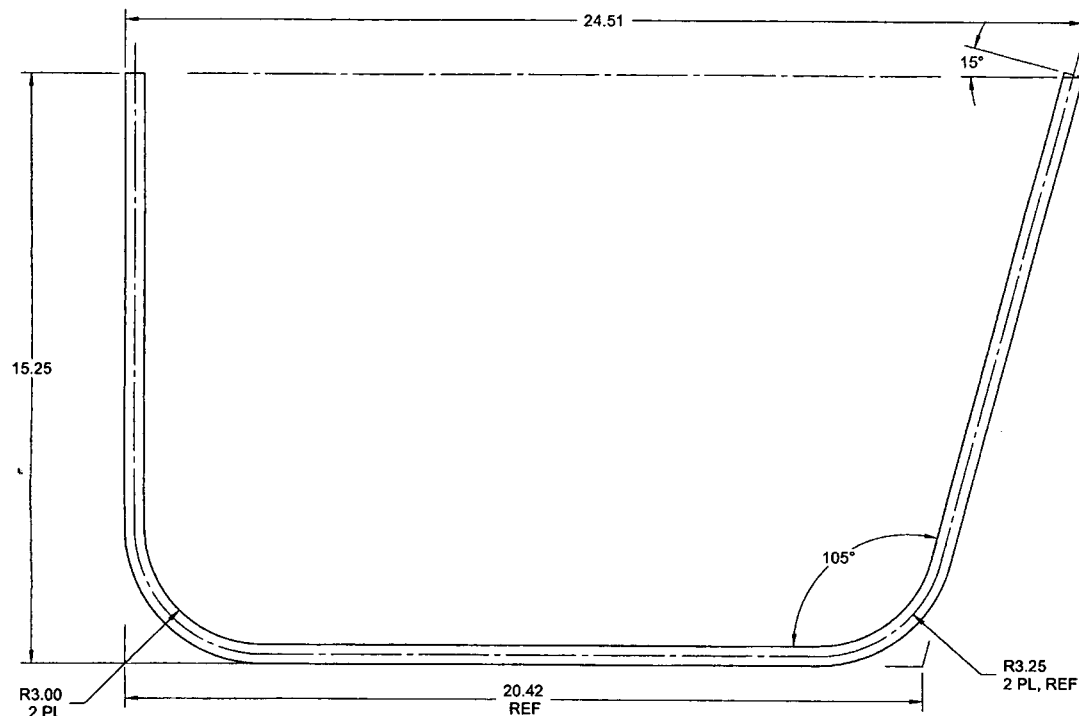
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D3916-5 LIGHT RIB

w/b 43624

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
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